Thursday, 3/8/2007 1:19:13 PM

User:

Kim Johnston

**Process Sheet** 

**Drawing Name** 

Part Number

**Drawing Number** 

Project Number

**Drawing Revision** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31124

**Estimate Number** 

: 12530

P.O. Number

: NA

This Issue Prsht Rev.

First Issue

Previous Run

: 3/8/2007

: NC

: NA

S.O. No. : NIA

: SMALL /MED FAB

: 30636

Written By Checked & Approved By

Comment

: Est Rev.

New Issue 06-09-18 JLM

**Material Due Date** 

: 3/30/2007

: BRACKET

: D35471

· D3547

: N/A

Qty:

10 Um: Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M2024T3S125



2024-T3 .125 sheet

Comment: Qty.:

0.0557 sf(s)/Unit Total:

0.5565 sf(s)

2024-T3 .125 Sheet (M2024T3S0125)

Batch: <u>1102087</u>

2.0





1-Cut as per Dwg D3547 Dwg Rev: #

Prog Rev:\_\_\_\_\_

\*\*\*\*Ensure Grain Direction is Correct\*\*\*\*\*

SAD

07103111

2-Deburr if necessary

3.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

BRAKE NO

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3557

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							£1			
							j.			
							9			

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA: Date: 07/03/	75
			QA: N/C Closed: Date:	_
NCR:	V	WORK ORDER NON-CON	NFORMANCE (NCR)	

NCR:		WORK ORDER NON-CONFORMANCE (NCK)							
		Description of NC Corrective Action Section B				Verification Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector	
						C			
		And the second s							
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			1						

NOTE: Date & initial all entries

Thursday, 3/8/2007 1:19:13 PM Date: 5 User: Kim Johnston **Process Sheet** Drawing Name: BRACKET Customer: CU-DAR001 Dart Helicopters Services Part Number: D35471 Job Number: 31124 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 HAND FINISHING1 7.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 POWDER COATING M103706 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 POWDER COAT/CHEMICAL CONVERSION 10.0 PACKAGING 1 PACKAGING REA Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion 1 07W3-19

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву		By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			-								
								:			
Part No	:	PAR #: Fault Category:	NCR:	Yes	No DQ	<b>A</b> :	Date:				

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

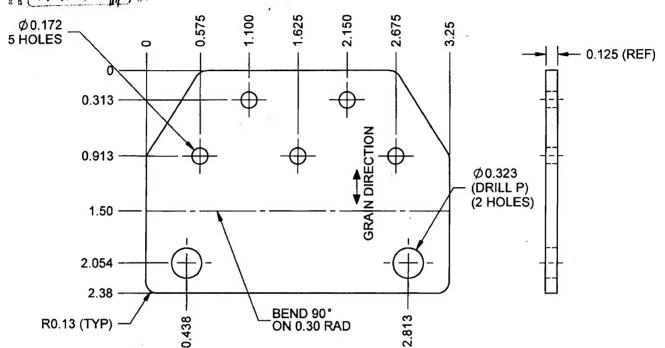
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		STED Description of NC		Corrective Action Section B			A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
				*						
			7	1						

NOTE: Date & initial all entries



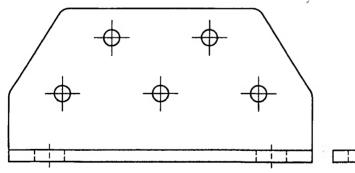
	DESIGN C	DRAWN BY		OSPACE LTD ONTARIO, CANADA
	CHECKED PH	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
	DATE <b>06</b> .1	0.06	BRACKET	SCALE 1:1
_	REV	DATE	DESC	RIPTION

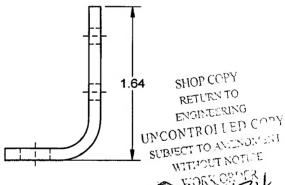
**NEW ISSUE** 



06.10.06

### **D3547-1F FLAT PATTERN**





### **D3547-1 BRACKET**

NOTES: 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11

(REF DART SPEC M6061T6S.125)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD	Work Order: 31124		
Description: Bracket	Part Number: <b>13547-1</b>		
Description: Gractet			
Inspection Dwg: 02547.1. Rev:	. Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	( X	First Artic	ie 2	Prote	whe	and the second s
Drawing Dimension	Tolerance	Actual Dimension	Accept	.ejest	Method of Inspection	Comments
0.313	1/- 0.010	0.316	/		Vern	
0,913	+4 0,010	0.916	1		Vern	
130	th				ventical	
2,054	+1- 6.010	2.056		-	vern	
2.38	+1- 6.036	2.38			Vern	
0.438	+1- 0.010	0,440			Vern	
2.813	++ 0.010	2.816	1		Vern	
0.575	+1-0.610	0.5.80	V		Vertical Vern	and the second of the second o
1.100	1-0,010	1.105			Vertical Vert	
1.675	+1-0,010	1.630	V		vertical vertical	
2.150	+1-0.010	2148	/		Vers	and the second second second second
2.675	1/- 0.010	2.680	/		vertical	
3.25	+1.0.030	3.26		9.7	Vertical Ven	and the second s
06.172	+1-0.005	Ø0.172	/		Vern	
Ø0.323	1/0.006	Ø0.323			Vern	
0.125	+1-0.010	0.123			Vern	
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Measu	ired by:	SAO	Audited by:	M	Prototype Approval:	WH.
	Date:	07/03/11	Date:	07/03/12	Date:	
Rev	Date	Change			Revised by	Approve
A		New Issue			KJ/JLM	

